Work Order ID 100806

May 1, 2013 7:26:18 AM

100806

N900040100

Setup Start

Page 1

Item Name:

GWT Knob 4/25/13

D3954-3

Start Qty: 12.00

Req'd Qty: 12.00

12 *12*

Cust Item ID:

Customer:

Reference:

Start Date:

*Item ID:

Revision ID:

Approvals: Process Plan:

Required Date: 4/30/13

Date:

Run

Rejuct Namber

 $QC: \cdot$

Date:

SPC (Y/N):

Accept

Date:

Mora Costa 🖅 🤲 Secolitic in Draw Nbr **Revision Nbr** D3954

100 Waterjet

Memo

0.00

0.00

*Kejeci

QQ

ELOW CNC Waterjet

304, 375" × 3 00"

1-Cut as per Dwg D3854

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

7~13-07-32

110 QC

0.00

Quality Control

										DQA:	Date	e:
NCR: Y	es / No				WORK ORDER NON-C	O	4FORM	MANCE / UPDATE			_	
• 							QA Closed: Date:					
Work Orde	÷:				DISPOSITION	ĺ		AGAIN	ST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		1		Descri	ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data												
quip/Tooling		1					İ					
perator					•						٠	
/laterial												
etup												
Other							:			1		
rocess				İ		1				ļ		
upplier		Ì				•						
raining												
Inapproved						L						
					F	AUL	LT CATE		٠			
Landin	g Gear				General	-4,	_	AND THE	. , 115	_	-	\$ 2.
	Bending				Bend	L	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa		L	Over/Under	- -	Temperature/Cure
	Cracks				Broken/Damaged	\perp	-1	ion Incomplete	<u> </u>	Part Incorre	F	Weld
	Crushed	/Crimped			Burrs	<u></u>		tions Incomplete/Unclear	oxdot	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance	L	Part Moved		
	Heat Tre	eat			Countersink	L	Mislabe	eled	_	Positioned V		
Inspection Strip in Tube			Cut Too Short		Misrea	d		Power Loss/	Surge [Other		
Ripples in Bend				Drill Holes		Offset						
	Torque	Waves in I	Extrusio	n L	Drawing		-i	Calibration				
		Sequence			Finish	_	Out of	Sequence				
	Wave/T	wist in Tu	be		Folio		Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Order ID 100806

May 1. 2013 7:26:18 AM

100806

Item ID:

D3954-3

Accept

N900040100

Setup Start

NS2

Revision ID:

Item Name: **GWT Knob**

Start Date: 4/25/13

Required Date: 4/30/13

Start Oty: 12.00 Req'd Qty: 12.00 *12* *12*

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

Date:

Tooling:

Date:

Run

OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

QC8- Inspect parts - second check

Memo

Set Un/ **Run Hours** 1000110

Accept Reject Tool# Plau Code

Oty Oty Number Samp

Reject

120

Quality Control

0.00

130

120[†]

130

Mill Conv

Memo

0.00

0.00

Conventional Milling Machine

1-OPEN TO TAP DRILL SIZE

2-TAP AS PER DWG D3954

MIP 13/04/30 12 D

140

QC5- Inspect part completeness to step on W/O

0.00

140

ÒC

Memo

0.00

Óuality Control

										DQA:	Dat	e:	
NCR: Ye	es / No				WORK ORDER NON-C	ON	1FORN	AANCE / UPDATE					
										QA Closed:	Dat	e:	
Nork Orde	r <u>.</u>				DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
					Rework	1		Skid-tube Crosstube	_	Water Jet			Engineering
Part No	٥.				Scrap			Machining Small Fab		Prod. Eng. Coor.			Quality
			······································	····	Use-as-is	1 1	i	noforming Finishing		4	e/Packaging	ヿ	Other
NCR N	0.				Work Order Update	1		Large Fab Composite	⊢]	Supplier	コ	
											_		
Root				Descri	ption of work order update	- 11	nitial	Action		Sign &			
Cause	Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	Description		Date	Verification	١.	QC Inspector
oc/Data													
quip/Tooling						1							
perator													
//aterial													
etup	_												
Other													
rocess	4					1							
upplier	4	l .					ž.						
raining	_							•					
Inapproved			<u> </u>	<u> </u>		<u> </u>	TCATE	CORY		<u> </u>			
11 25 45	- 1		ىقىزە 124 يالىرىي			AUL	T CATE	, . (, ; , ,				—	
Landin F	Bending	·	ه ۱۳۳۰ ور:		General Bend		Grain	e e e e e e e e e e e e e e e e e e e	Г	Ovalized		\neg	Pressure/Forced
-	Centre N	ot Conce	ntric to		BOM/Route	H	Hardwa	re	H	Over/Under	tolerance		Temperature/Cure
ŀ	Cracks	or conce	intino to),	Broken/Damaged		1	ion Incomplete		Part Incorre	ŀ		Weld
ŀ	Crushed/	Crimped		<u> </u>	Burrs	\vdash	4 '	ions Incomplete/Unclear	一	Part Lost/M	ŀ		Wrong Stock Pulled
-	Cuffs				Contamination		Mainte			Part Moved			-
Heat Treat				Countersink		Mislabe	eled		Positioned V	Vrong			
Ţ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge		Other
			Drill Holes		Offset								
Torque Waves in Extrusion Drawing				Drawing		Out of (Calibration						
Turning Sequence Finish					Finish		Out of S	Sequence					
Wave/Twist in Tube				Folio		Outside	Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

May 1. 2013 7:26:18 AM

Item ID:

D3954-3

GWT Knob Item Name:

Required Date: 4/30/13

Start Date:

Revision ID:

4/25/13

OC:

Start Oty: 12.00

Req'd Qty: 12.00

12

12

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

0.00

Accept

SPC (Y/N):

P Up/

Aan Hours

Date:

Date:

N900040100

Run Start

Setup Start

NS2

Stop

Stop

Sequence (D/

Work Center ID 170

170

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

0.00

Tour ID

i col# Plan Code

Accept -Qty

Reject Reject Otv

Insp. Mumber Stamp

120

OC **Ouality Control**

Memo

Memo

0.00

0.00

MU 130801

MLS 13-08-01

NCR:	Yes	1	No

DQA: Date:

NCR: Ye	es / No				WORK ORDER NON-C	ONFO	RIMANCE / UP	DAIE	QA Closed:	Date	:		
		•			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Order	r:				Davie de l'	, 🛔	Skid-tube	Crosstube	1	Water Jet Engineering			
Doet No	•				Rework	i	Machining Machining	Small Fab	Pro	d. Eng. Coor.	Engineering Quality		
Part No	o				Scrap Use-as-is	The	rmoforming	Finishing		re/Packaging	Other		
NCR No	0				Work Order Update	'''	Large Fab	Composite	1 (160/310)	Supplier			
WCK IV	·				Work Order opuate	J	curge ruo	COMPOSITE [J				
Root				Descri	ption of work order update	Initia	Ac	ction	Sign &				
Cause	Date	Step	Qty	C	or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector		
Doc/Data													
quip/Tooling		}											
Operator	_												
Material	_					ļ					1		
Setup	_		1										
Other													
Process							1						
Supplier						}							
Training													
Unapproved		<u> </u>				<u> </u>			<u> </u>		<u> </u>		
					F	AULT CA	TEGORY						
Landin	g Gear				General	_		_	7	_	- -1		
	Bending				Bend	Grai	n	<u> </u>	Ovalized		Pressure/Forced		
L	Centre No	ot Conce	ntric to (D/S	BOM/Route	Hard	ware		Over/Under		Temperature/Cure		
	Cracks			L	Broken/Damaged	—	ection Incomplete		Part Incorre	<u></u>	Weld		
	Crushed/	Crimped			Burrs	_	uctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination	<u></u> Маі	ntenance	<u></u>	Part Moved				
	Heat Trea	at			Countersink	Misl	abeled	<u>_</u>	Positioned \		¬		
	Inspectio	n Strip in	Tube		Cut Too Short	Misr			Power Loss/	'Surge	Other		
	Ripples in	n Bend			Drill Holes	Offs							
	Torque V	Vaves in 1	Extrusion	n [_	Drawing	Out	of Calibration						
	Turning S	Sequence	!		Finish	Out	of Sequence						
	Wave/Tv	vist in Tu	be		Folio	Out	ide Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

May 1, 2013 7:26:18 AM

Work Order ID:

100806

Parent Item:

D3954-3

Parent Item Name:

GWT Knob

Start Date: 4/25/13

Required Date: 4/30/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	M304B0.375X03.000		Purchased	No			100	f	16.1080	0.02778	9 .350905 2	2		
ĺ	M304 SS bar .375 x 3.00										0,35	2 FT	•	JnB-07-22

Location	Loc Qty	Loc Code
MAT05!	16.108	
120204	2.078	
105040	12.83	

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: DISPOSITION											DQA:	Date:	
Work Order: Part No. Part No. Scrap Use-as-is Work Order Update NCR No. Description of work order update or Non-conformance Deperator Stepp/Tooling Supplier Faultr CATEGORY Landing Gear General General General General General Hardware Hardware Hardware Hardware Hardware Hardware Part Incorrect Part Incorrect Weid Wrong Stock Pulled Part Moved Positioned Wrong Power Loss/Surge Other Other Other Other Other Double Other Other Double Other Double Other Other Double Other Do	NCR: Ye	es / No				WORK ORDER NON-	CON	1FORM	/ANCE / UP	DATE	QA Closed:	Date:	
Part No.	Work Order	•				DISPOSITION				AGAINST DE			
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data D	Part No	D				Scrap _ Use-as-is	Scrap Machining Use-as-is Thermoforming		Machining noforming	Small Fab Finishing	-1	d. Eng. Coor. re/Packaging	Quality
Containing Con		Date	Step	Qty		•						Verification	QC Inspector
FAULT CATEGORY Landing Gear Bending Centre Not Concentric to O/S Cracks Cracks Broken/Damaged Cuffs Contamination Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Cidente Seneral Grain Grain Hardware Hardwar	Equip/Tooling Operator Material Setup Other Process Supplier Training												
Bending			1				FAUL	T CATE	GORY				
Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Crushed/Crimped Cuffs Contamination Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Drill Holes Drill Holes Over/Under tolerance Part Incorrect Weld Wrong Stock Pulled Part Lost/Missing Part Moved Part Moved Positioned Wrong Power Loss/Surge Other	Landin	g Gear				General					_		_
Torque Waves in Extrusion Drawing Out of Calibration	Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset	rdware spection Incomplete structions Incomplete/Unclear aintenance slabeled sread fset		Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V	ct sissing Vrong	Temperature/Cure Weld Wrong Stock Pulled		
Torque Waves in Extrusion Drawing Out of Calibration	}				" -		4						

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	100804
Description: GWT Knob	Part Number:	D3954-3
Inspection Dwg: D3954 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/-0.030	0.637	_		V	JEMOI
0.75	+/-0.030	0.757			V	
2.00	+/-0.030	9.003,	•		~	
2.00	+/-0.030	2-004"	-		V	
0.38	+/-0.030	0.376	-		L	
		·				
······································						
			D4	,		

Measured by:	JM	Audited by:	4	Preliminary Approval:	
Date:	13-07.22	Date:	13723	Date:	

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	
В	09.11.04	Dwg Rev updated	KJ	
С	12.03.08	Dwg Rev updated	KJ 🗘	
D	13.02.27	Dwg Rev updated	KJ 🛠	
				7





